

Deels

Work Order ID 75477

75477

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October-24-11 10:19:45 AM

Item ID: D2654-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Web,
 Start Date: 24/10/2011 Start Qty: 10.00 *10* Cust Item ID:
 Required Date: 01/12/2011 Req'd Qty: 10.00 *10* Customer:
 Reference:

Approvals: Process Plan: M.L.J Date: 11/10/24 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2654	F

100	Skidtubes	0.00
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100
 Skidtubes
 Skidtubes
 Memo
 1-Cut D2600-5 to length as per Dwg D2654
 2-Drill pilot holes in web using drill jig DT 8018-1 as per Dwg D2654
 3-Using the uni-bit, open holes to finish size as per Dwg D2654
 4-Deburr holes and ends

110	QC5- Inspect part completeness to step on W/O	0.00
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110
 QC
 Quality Control
 Memo
 0.00

120	Chemical Conversion Coat per QSI005 4.1	0.00
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120
 HandFinish
 Hand Finishing
 Memo
 0.00

CS 11 11 10 (10)

DP 11-11-10

DT 11-11-10 (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							
140 *140* Packaging Packaging	Identify as per dwg & Stock Location: <u>46</u> Memo	0.00 0.00							
150 *150* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

11-11-10
MF
11-11-10

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Work Order ID: 75477

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Parent Item: D2654-1

D2654-1

Parent Item Name: Web

Start Date: 24/10/2011

Required Date: 01/12/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:D 99.02.04 Fixed typo, Changed procedure DM
IPP Rev:E 08-06-10 revE1 as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2600-5-108		Manufactured	No			100	Each	272.0000	1	10			

D2600-5-108

Extrusion 'I Beam' thin

080

73867

RT 11-11-09

Location

Loc Qty

Loc Code

LG

272

47814

20

73909

252

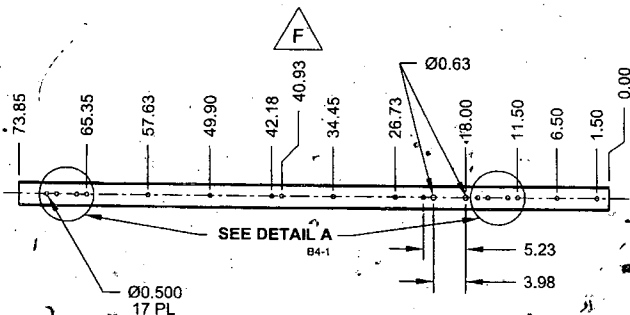
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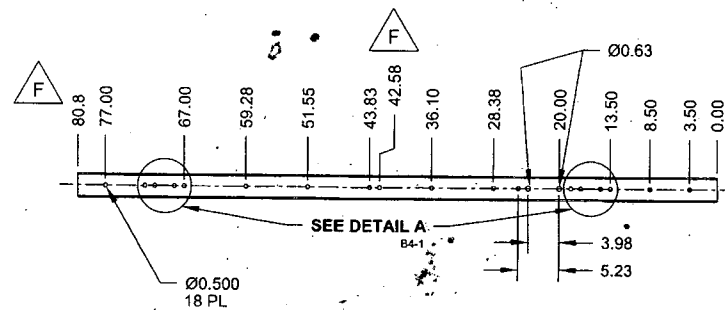
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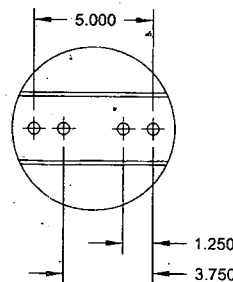
NOTE: Date & initial all entries



D2654-1 WEB



D2654-3 WEB



DETAIL A

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 75477 M.C.J
11/10/24

RELEASED
2011-09-12

NOTES:

- 1) MAKE D2654-1/-3 FROM D2600-5-108 EXTRUSION, MAKE D2654-5/-7 FROM D2600-7-125 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH P/N "D2654-X" PER QSI 044 6.1 (FINE POINT PERMANENT INK MARKER)
- 7) WEIGHT: D2654-1 = 2.2 lbs; D2654-3 = 2.4 lbs
D2654-5 = 4.8 lbs; D2654-7 = 5.8 lbs

DESIGN	CP	DART AEROSPACE USA, INC	
DRAWN	SC	PORT HADLOCK, WA	
CHECKED	CP	DRAWING NO.	REV. F
MFG. APPR.	CP	D2654	SHEET 1 OF 2
APPROVED	CP	TITLE	SCALE
DE APPR.	CP	WEB	NTS
DATE	11.05.05	COPYRIGHT © 1997 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS LOANED TO THE EXPRESS PERSON TO WHOM IT IS NOT TO BE USED FOR ANY PURPOSE OR COME OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

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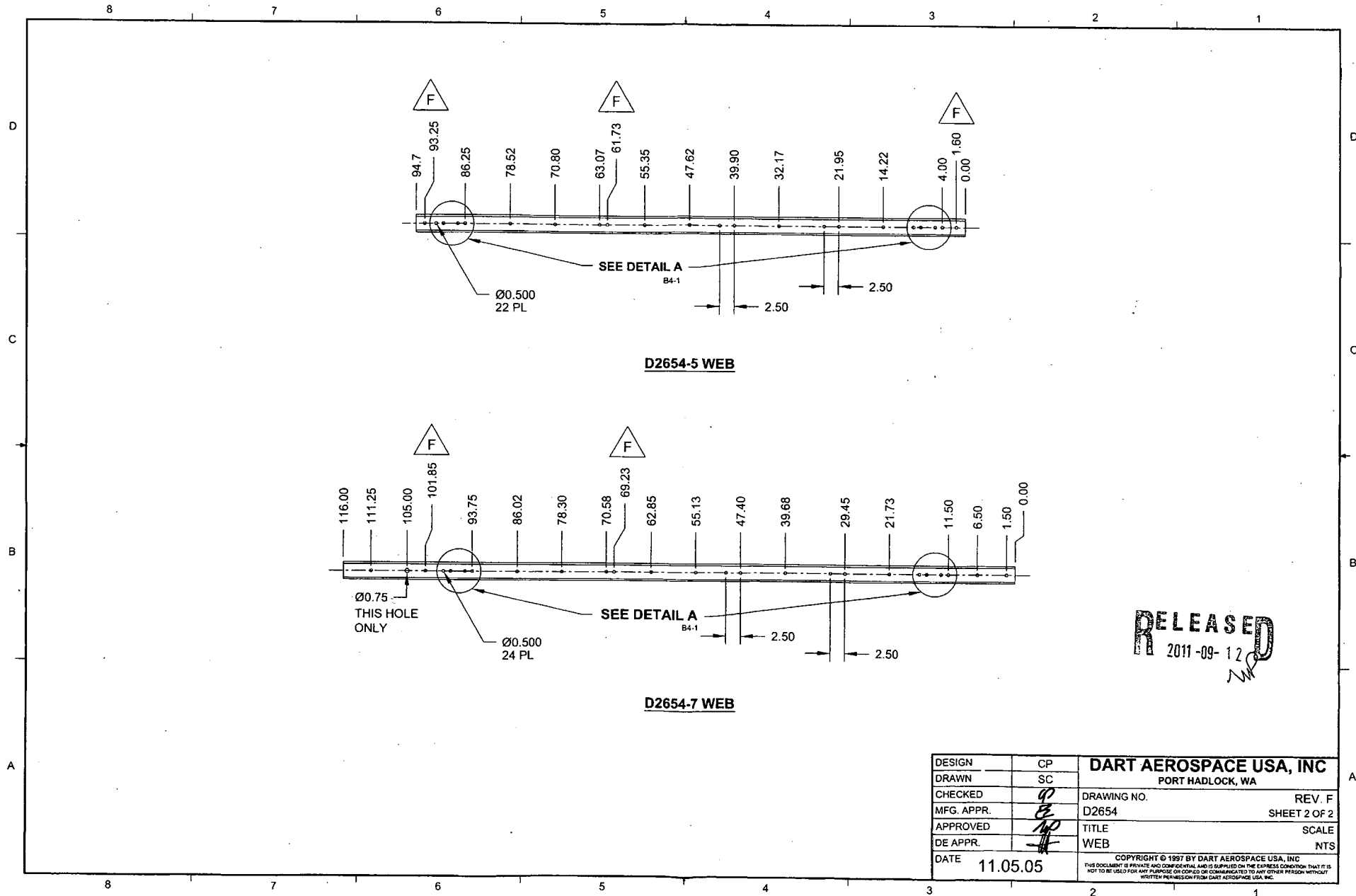
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